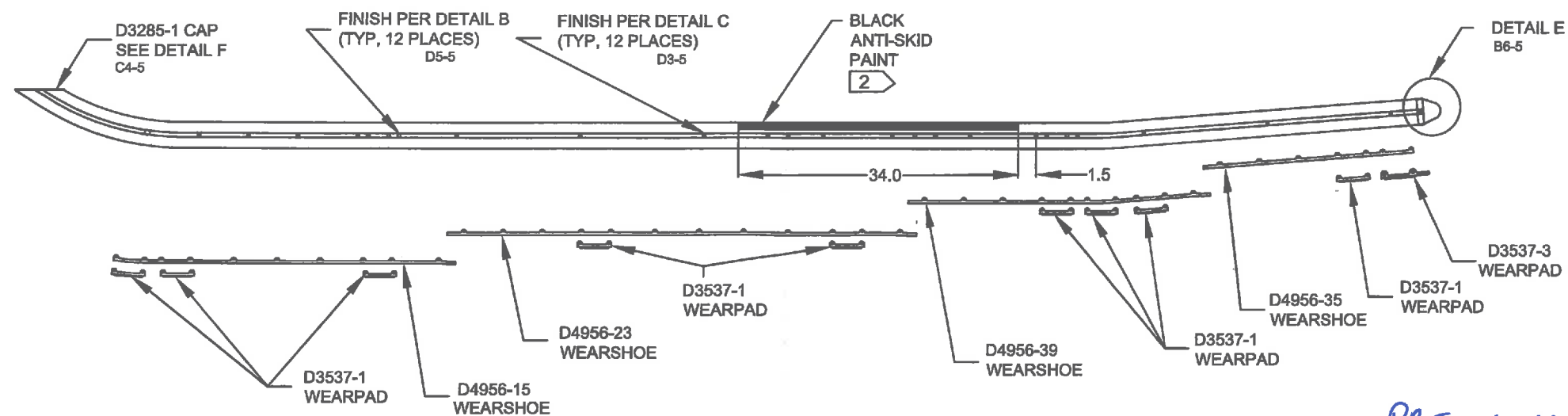
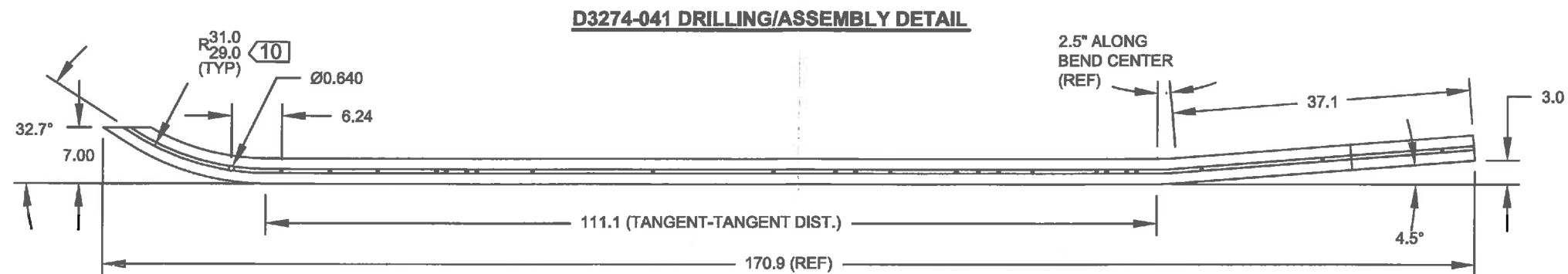
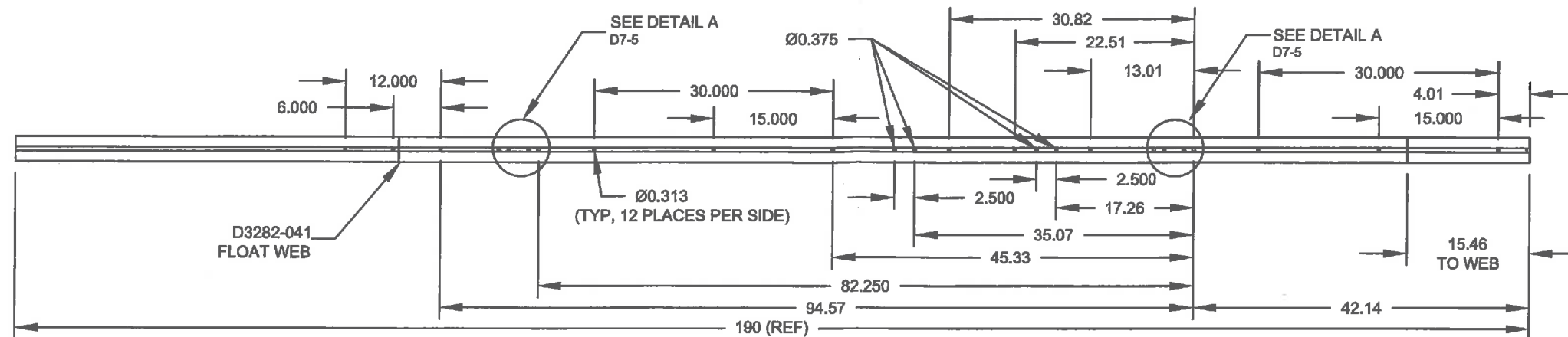


Table with 5 columns: Qty -041, Qty -043, Qty -045, Part Number, Description. Rows include SKIDTUBE ASSEMBLY, EXTRUSION, AFT CAP, CROSS BOLT SPACER, FLOAT WEB, CAP, RING, NUT PLATE, WEARPAD, WEARSHOE, INSERT, BOLT, WASHER, RIVET, and SCREW.

GENERAL NOTES:

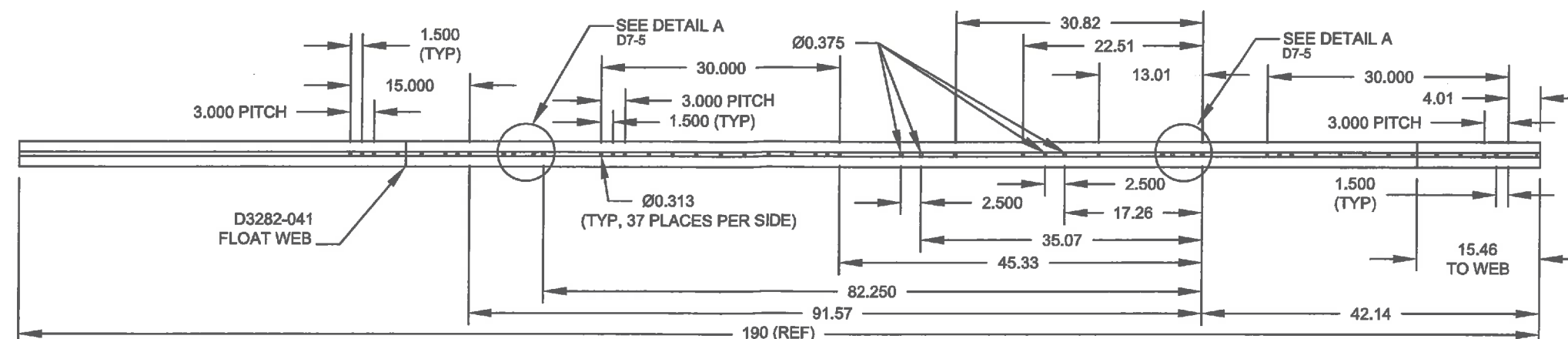
- 1. MATERIAL: N/A
- 2. FINISH:
  - ON -041/-043: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) OUTSIDE ONLY AND PAINT WHITE PER DART QSI 005 4.2 BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
  - ON -045: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D3282-041 WEB PRIME (REF. 4.2.1.3.3) INSIDE AND OUTSIDE PER QSI 005 4.2.1 PAINT BLACK PER QSI 005 4.2.2 USING CA8213/F37038 CAMOFLAGE BLACK PER MIL-PRF-05285E TYPE I CLASS H. BLACK ANTI-SKID PAINT AS INDICATED TO 0.5" ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4. UNITS: INCHES UNLESS OTHERWISE NOTED
- 5. BREAK SHARP EDGES 0.005 TO 0.010 MAX
- 6. IDENTIFICATION: N/A
- 7. WEIGHT: FOR -041/-043 = 37.5 LBS FOR -045 = 33.4 LBS
- 8. WELDING TO BE DONE PER DART QSI 004.
- 9. ALL HOLES DRILLED ON CENTERLINES.
- 10. DAMAGE TOLERANCE ON FWD BEND: THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020" DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 11. BOND D3282-041 FLOAT WEB INTO D3274-1/-3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
- 12. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEX -241/-291. ON -045, DO NOT DRILL HOLES OR INSTALL INSERTS FOR LONG WEARPLATES.
- 13. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS GREASE WITH WASH 'N WIPE DEGREASER.
- 14. ON -045, APPLY COAT OF ROCKGUARD TO SKIDTUBE WHERE WEARPADS ARE INSTALLED.

Table with 4 columns: REV., DESCRIPTION, BY, DATE. Includes revision history and design information for DART Aerospace USA, Inc.

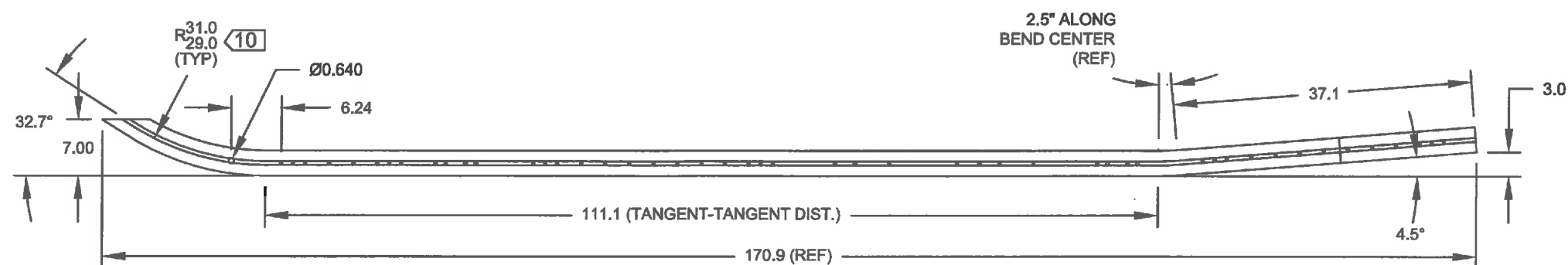


PRELIMINARY # 2015.05.16

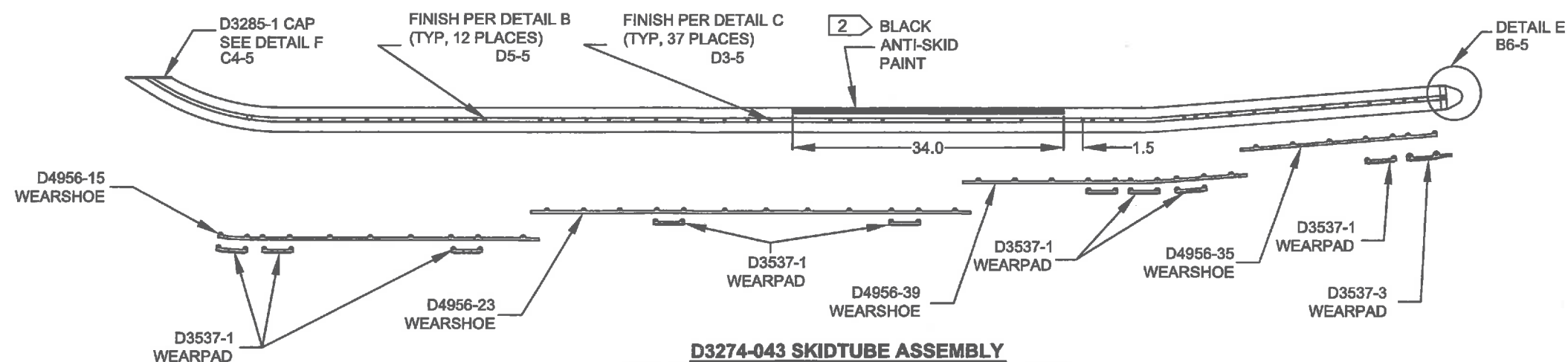
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 2 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.	#	SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



**D3274-043 DRILLING/ASSEMBLY DETAIL**



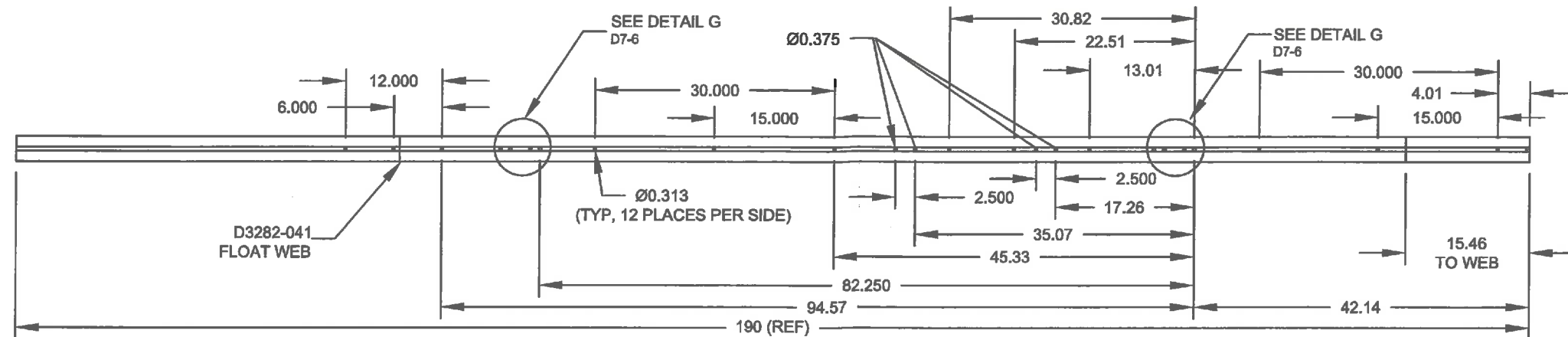
**D3274-043 BEND/DRILLING DETAIL**



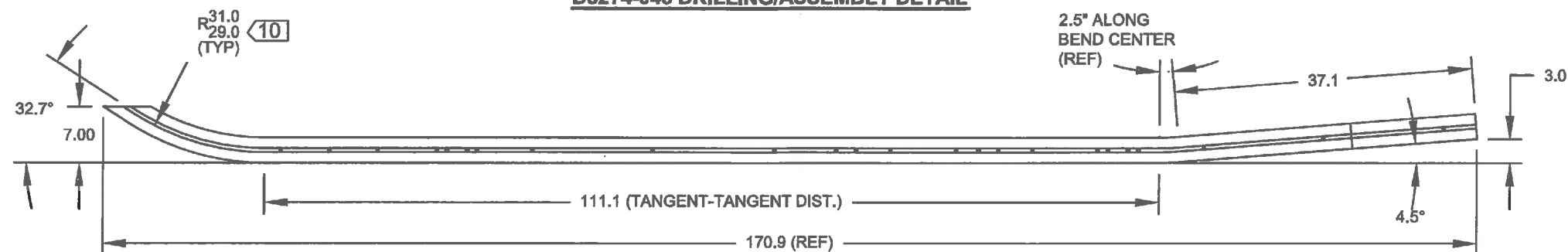
**D3274-043 SKIDTUBE ASSEMBLY  
(SEE DETAIL D FOR WEARSHOE INSTALLATION)**

PRELIMINARY 2016.05.16

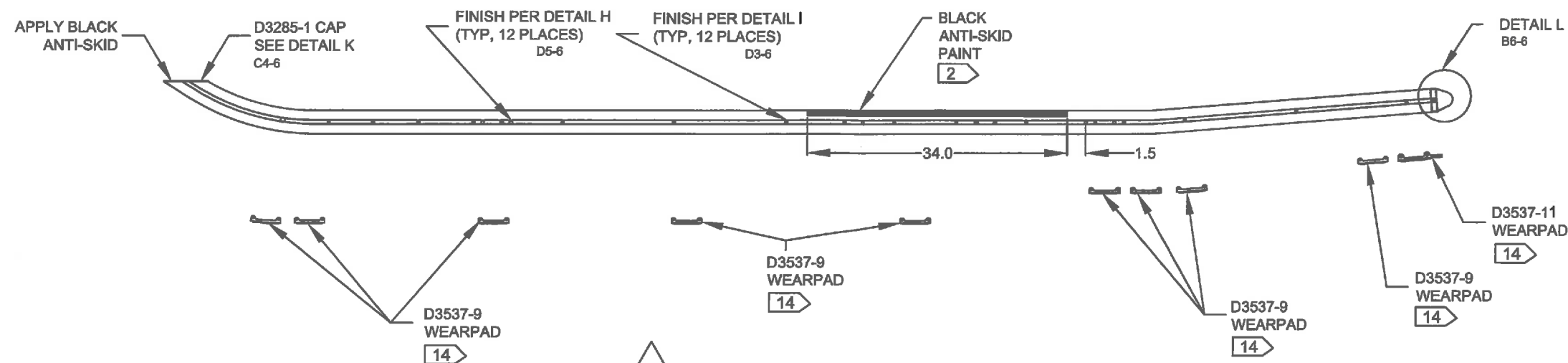
DESIGN	CP	<b>DART AEROSPACE USA, INC</b> EUGENE, OR	
DRAWN	RF		
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 3 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
DATE	16.04.25	COPYRIGHT © 2004 BY DART AEROSPACE USA, INC <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



**D3274-045 DRILLING/ASSEMBLY DETAIL**



**D3274-045 BEND/DRILLING DETAIL**

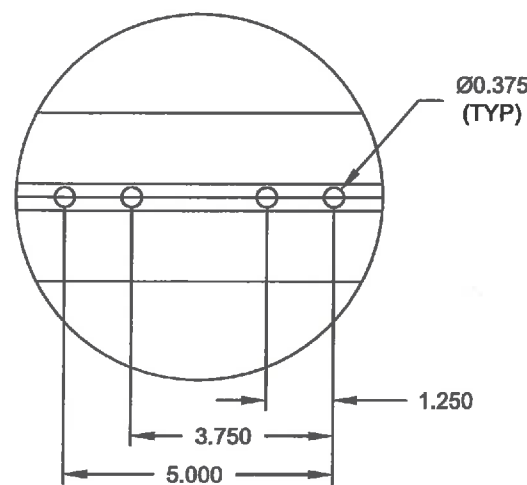


**D3274-045 SKIDTUBE ASSEMBLY**  
(SEE DETAIL J FOR WEARSHOE INSTALLATION)

PRELIMINARY 2016-05-16

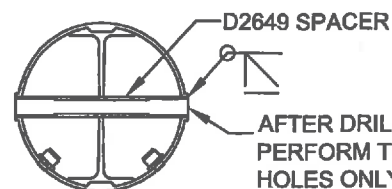
DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 4 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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**DETAIL A: DRILL DETAIL**  
D6-2, D3-2, D5-3, D3-3



**DETAIL B**  
B6-2, B5-3

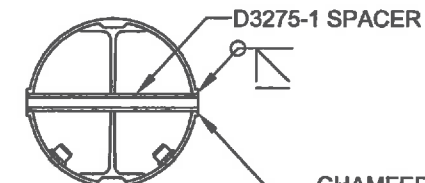
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375  
HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE TO Ø0.313x0.75 DEEP

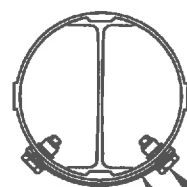
**DETAIL C**  
B5-2, B4-3

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°  
(TYP)

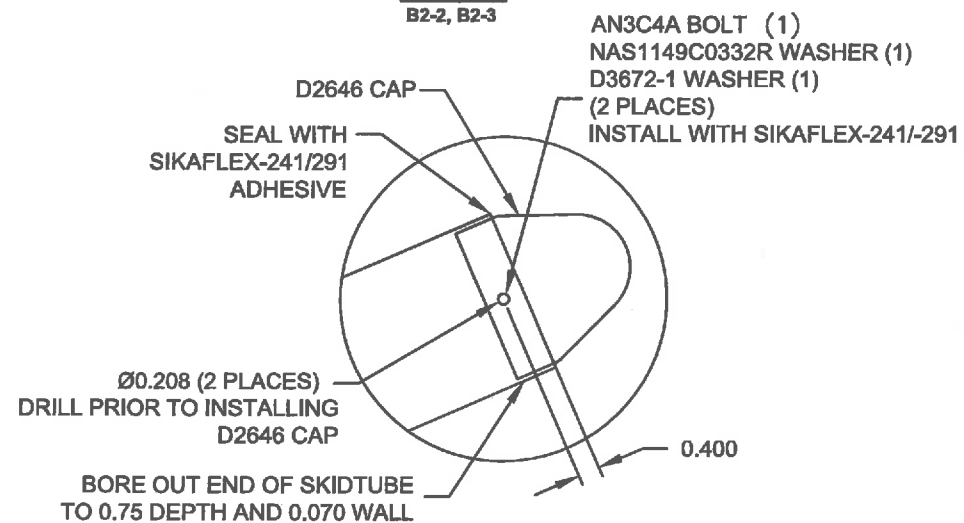
**DETAIL D**  
A4-2, A4-3



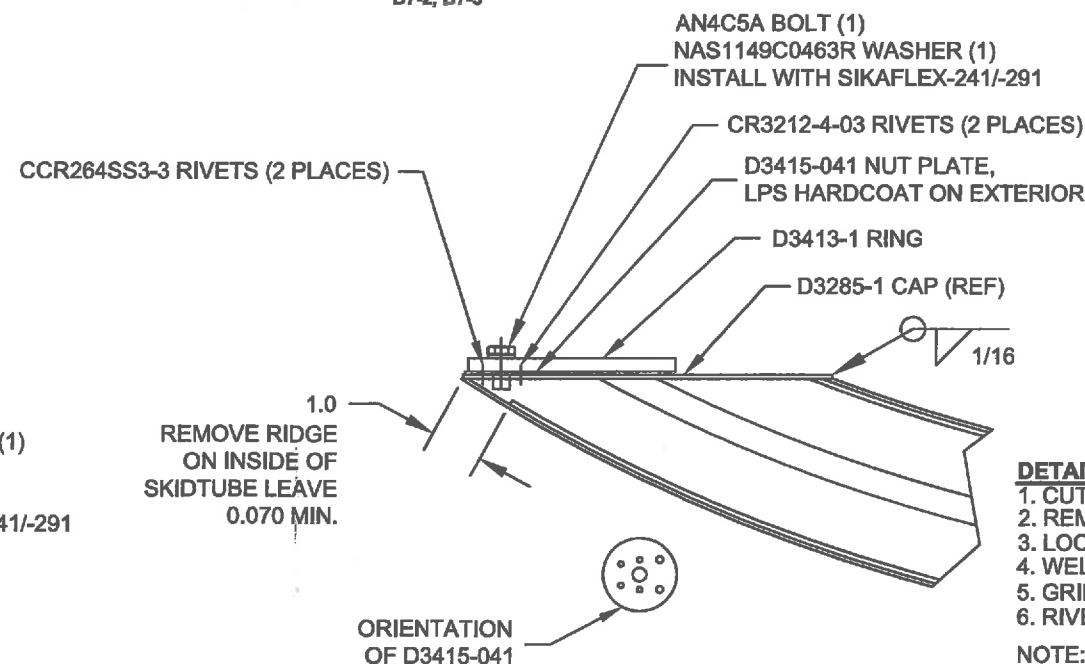
ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
NAS1149C0332R WASHER (1)  
(78 PLACES)

WEARSHOE/WEARPAD (REF)

**DETAIL E**  
B2-2, B2-3



**DETAIL F: END FINISHING DETAIL**  
B7-2, B7-3



**DETAIL F NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH

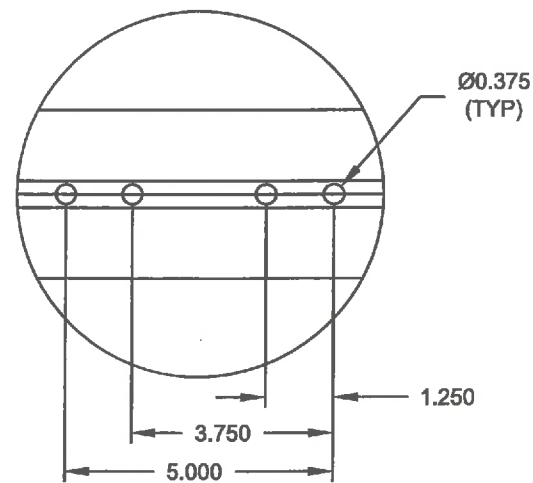
**-041/-043 DETAILS**

*PRELIMINARY # 2016-05-16*

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CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 5 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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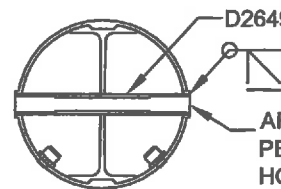


**DETAIL G: DRILL DETAIL**  
D6-4, D3-4



**DETAIL H**  
B6-4

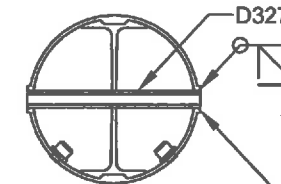
FOR Ø0.375 HOLES ONLY



AFTER DRILLING AND BENDING ASSEMBLY  
PERFORM THE FOLLOWING FOR Ø0.375  
HOLES ONLY:  
1. CHAMFER HOLE 0.030x45°  
2. INSERT D2649 SPACER  
3. WELD INTO PLACE AND GRIND FLUSH  
4. C'BORE TO Ø0.313x0.75 DEEP

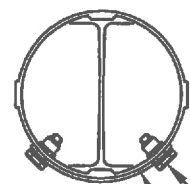
**DETAIL I**  
B5-4

FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°  
(TYP)

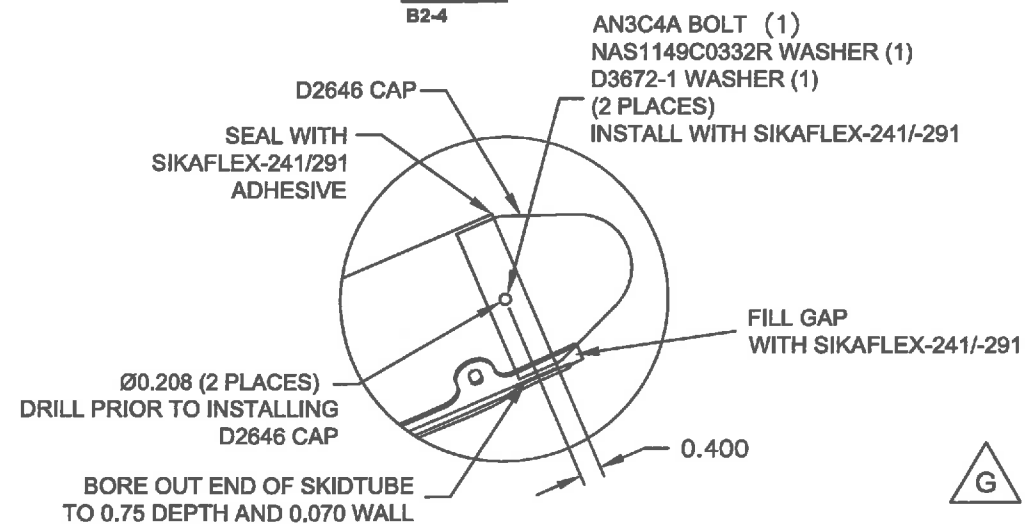
**DETAIL J**  
A4-4



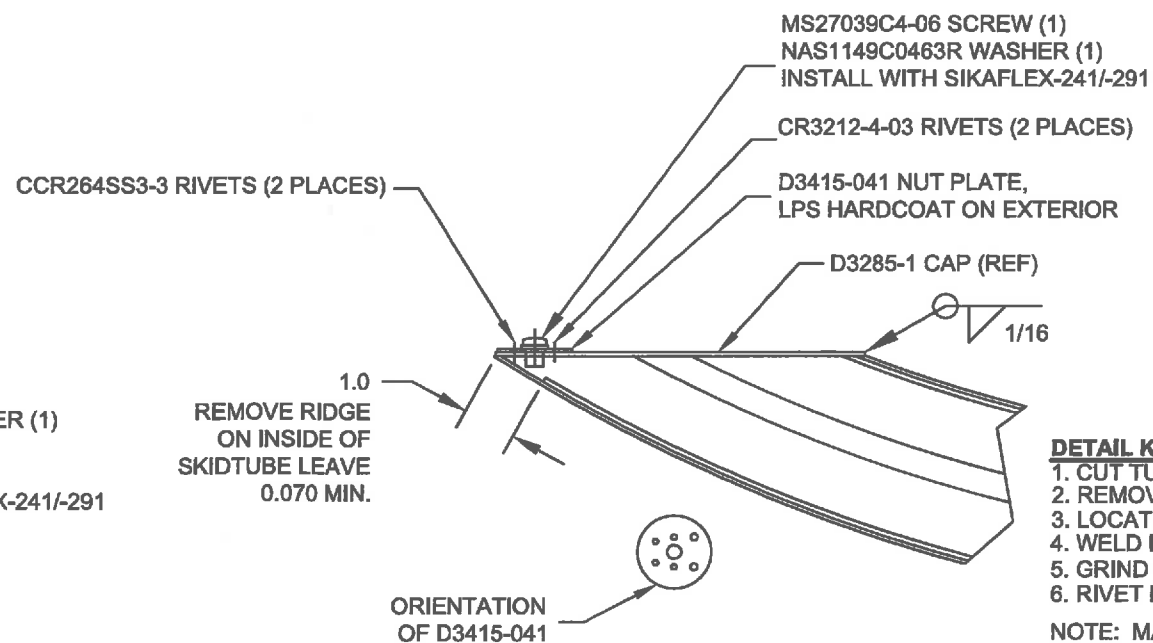
ALS7-1032-130 INSERT (1)  
AN3C4A BOLT (1)  
NAS1149C0332R WASHER (1)  
(40 PLACES)

WEARPAD (REF)

**DETAIL L**  
B2-4



**DETAIL K: END FINISHING DETAIL**  
B7-4



**DETAIL K NOTES**

1. CUT TUBE LEVEL
  2. REMOVE RIDGE ON FWD SIDE
  3. LOCATE D3285-1 (TRIM AS NECESSARY)
  4. WELD D3285-1 IN PLACE PER DART QSI 004
  5. GRIND FLUSH
  6. RIVET D3415-041 NUT PLATE IN PLACE
- NOTE: MASK THREADS IN D3415-041  
PRIOR TO FINISH



**-045 DETAILS**

*PRELIMINARY # 206-05.16*

DESIGN	CP	<b>DART AEROSPACE USA, INC</b>	
DRAWN	RF	EUGENE, OR	
CHECKED	AK	DRAWING NO.	REV. G
MFG. APPR.	JLM	D3274	SHEET 6 OF 6
APPROVED	DS	TITLE	SCALE
DE APPR.		SKIDTUBE ASSEMBLY	NTS
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